

Work Order ID 125637

October-17-14 10:48:02 AM

125637

Page 1

Item ID: D3536-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket Center
 Start Date: 10/17/14 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 10/22/14 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3536	Rev A

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
 Deburr if necessary

(26) 10/14/14

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

(26) 10/14/14

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

(26) DAS 38 9-80 OCT 21 2014

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location <u>FP-001</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

14/10/21 14/10/21 14/10/21

14-10-21

Picklist Print

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Parent Item: D3536-25

D3536-25

Parent Item Name: Gasket Center

Start Date: 10/17/14

Required Date: 10/22/14

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MNEO60S.063

Purchased

No

100

sf

190.2671

0.5956

11

MNEO60S 063

NEOPRENE SHEET 0.063

DC 14/10/18

Location

Loc Qty

Loc Code

MAT052

190.2671

M126546

2.3

M128339

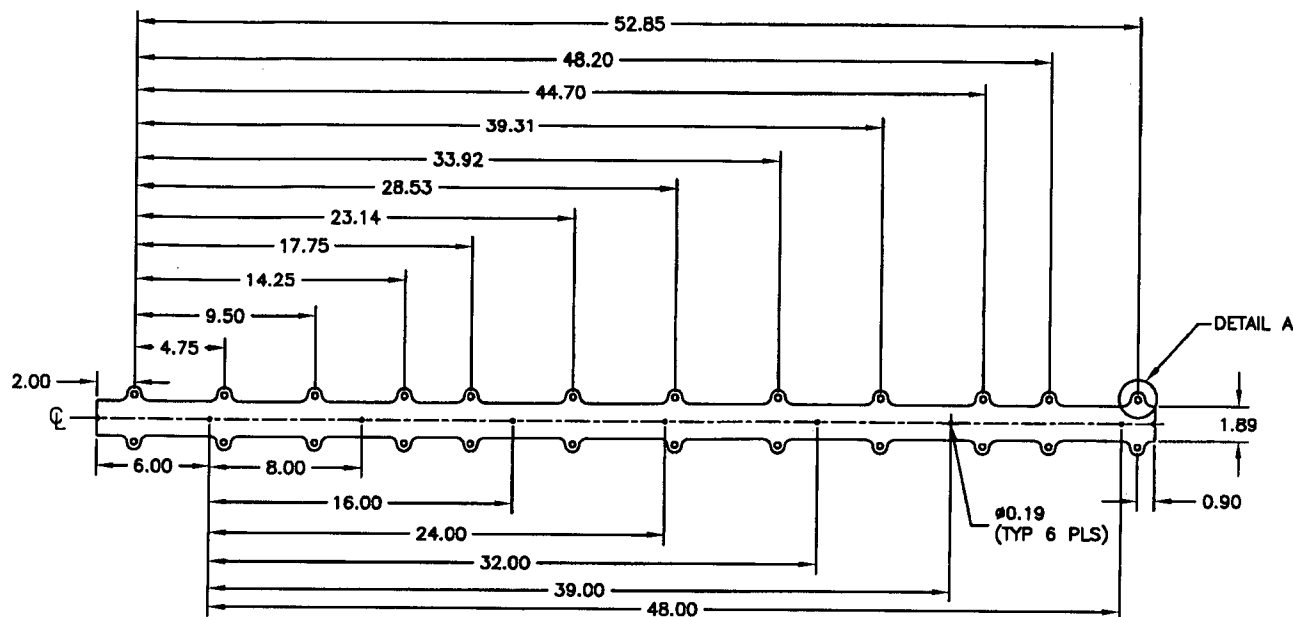
187.9671

18.333

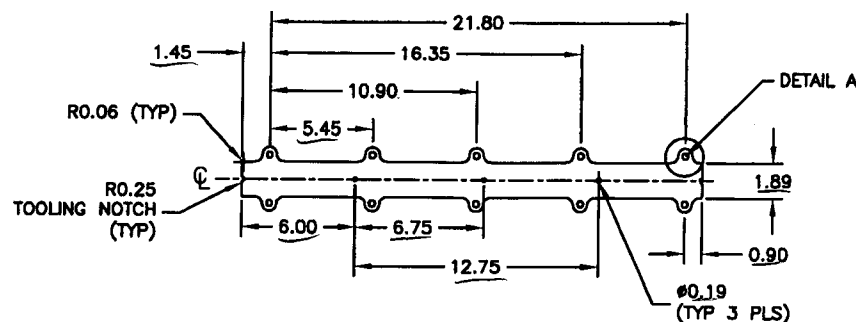
DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 3 OF 6
				SCALE 1:10

07.02.12
#

**D3536-23 GASKET**

w/6 125637

**D3536-25 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DART AEROSPACE LTD		Work Order: 125637
Description: Gasket Center		Part Number: 3536-25
Inspection Dwg: 3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .19	-.001 ^{+ .005}	.19	/		V=JKM-01	
.90	+/- .030	.90	/		T=JKM-06	
1.89	+/- .030	1.89	/			
1.45	+/- .030	1.45	/			
5.45	+/- .030	5.45	/			
6.00	+/- .030	6.00	/			
6.75	+/- .030	6.75	/			
12.75	+/- .030	12.76	/			
10.90	+/- .030	10.90	/			
16.35	+/- .030	16.35	/			
21.80	+/- .030	21.80	/			

DAS

Measured by: D-12	Audited by: 38 9-89	Preliminary Approval:
Date: 14/10/18	Date: OCT 21 2014	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	